Work Order ID 116106

116106

Friday, April 04, 2014 2:03:33 PM

Item ID: D4314-3 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Shim

Start Date: 4/04/14 **Start Qty:** 8.00 *8* **Cust Item ID:**

Required Date: 4/04/14 **Req'd Qty:** 8.00 *8* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** MLJ **Date:** 14-04-10 **Tooling:** _____ **Date:** _____ **Stop** *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
D4314 / A									
100	FLOW WATER JET	0.00				10		46	DAS 14/08/29
100								9-89	
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D4314 Dwg Rev: A Prog Rev: A 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				10		46	DAS 14/08/29
110								9-89	
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00				10			DAS 38 14-8-29
120									9-89
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

_____
_____
_____

Item ID: D4314-3
Revision ID:
Item Name: Shim
Start Date: 4/04/14 **Start Qty:** 8.00 *8*
Required Date: 4/04/14 **Req'd Qty:** 8.00 *8*
Reference:

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab					10x			14/09/02 DAS 36 9-89
Small Fab	**Memo**	0.00							
Small Fab	COUNTER SINK AS PER DWG								
150	QC5- Inspect part completeness to step on W/O	0.00							DAS 36 9-8
150						(10)			14-9-2
QC	**Memo**	0.00							
Quality Control									
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160						10	NG 14-9-3		
HandFinish	**Memo**	0.00							
Hand Finishing									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

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☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
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☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

Item ID: D4314-3 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Shim
Start Date: 4/04/14 **Start Qty:** 8.00 *8* **Cust Item ID:**
Required Date: 4/04/14 **Req'd Qty:** 8.00 *8* **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC7-Inspect Chemical Conversion Coat	0.00							
170 QC Quality Control	**Memo**	0.00				10	0	0	14/09/03
180	Identify as per dwg & Stock Location: ST098	0.00							
180 Packaging Packaging	**Memo**	0.00				10X			14-9-4
190	QC21- Final Inspection - Work Order Release	0.00							
190 QC Quality Control	**Memo**	0.00				MLJ 14-09-04			MLJ 14-09-04

DAS 26 9-89

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

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Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
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Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
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Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
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Supplier	☐									
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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

Picklist Print

Friday, April 04, 2014 2:03:33 PM

Work Order ID: 116106

116106

Parent Item: D4314-3

D4314-3

Parent Item Name: Shim

Start Date: 4/04/14 **Required Date:** 4/04/14

Start Qty: 8.00 **Required Qty:** 8.00

Comments: IPP REV:A NEW ISSUE 11-02-02 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.188		Purchased	No			100	sf	39.6500	0.0194	1			

M6061T6S.188

6061-T6 .188 Sheet

**

DAS 46 9-89 DC 14/08/29

Location	Loc Qty	Loc Code	
MAT021	39.65		
124572	39.65		0.2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

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Use-as-is ☐
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Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Process	☐									
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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

_____
_____
_____

DART AEROSPACE LTD	Work Order:	116106
Description: Shim	Part Number:	D4314-3
Inspection Dwg: D4314 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

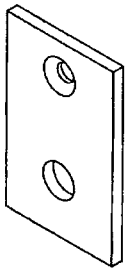
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.201	+0.005/-0.001	.200	✓		V=JKM-01	
Ø0.386	+0.006/-0.001	.386	✓			
0.67	+/-0.030	.67	✓			
1.125	+/-0.010	1.125	✓			
0.60	+/-0.030	.60	✓			
2.10	+/-0.030	2.10	✓			
1.33	+/-0.030	1.33	✓			
0.188	+/-0.010	.188	✓			

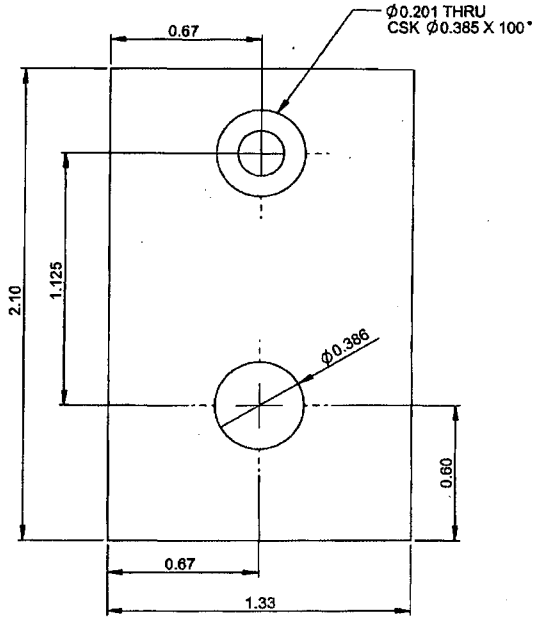
Measured by:	DAS 46 9-89
Date:	14/08/29

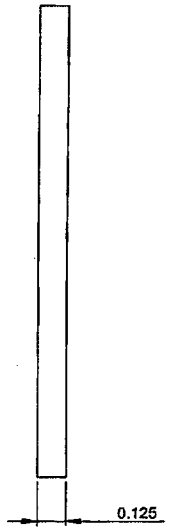
Audited by:	DAS 38 9-89
Date:	14-8-29

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	11.04.28	New Issue	KJ	







116106 MCO
14-04-10

RELEASED
2011-02-03

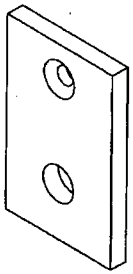
D4314-1 SHIM

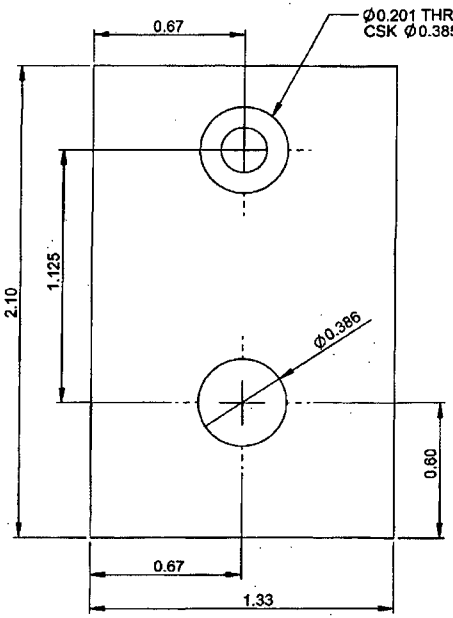
NOTES:
1) MATERIAL: ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.125)
OR
ALUMINUM 6061-T6/-T62 SHEET PER QQ-A-250/11 OR AMS-QQ-A-250/11
AMS 4025 OR AMS 4027 OR ASTM B209 (REF DART SPEC M6061T6S.125)
OR
ALUMINUM 5052-H32 SHEET PER QQ-A-250/8 OR AMS-QQ-A250/8
AMS 4016 OR ASTM B209 (REF DART SPEC M5052H32S.125)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER QSI 044 6.1
7) WEIGHT: 0.01 lbs

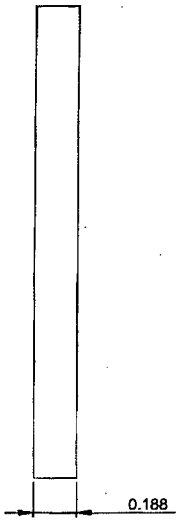
REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	SC	11.01.13

DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	SC	
CHECKED		DRAWING NO. D4314 REV. A
MFG. APPR.		SHEET 1 OF 2
APPROVED		TITLE SHIM SCALE NTS
DE APPR.		
DATE	11.01.13	

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D4314-3 SHIM

RELEASED
2011-02-01

NOTES:
1) MATERIAL: ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.188)
OR
ALUMINUM 6061-T6/-T62 SHEET PER QQ-A-250/11 OR AMS-QQ-A-250/11
AMS 4025 OR AMS 4027 OR ASTM B209 (REF DART SPEC M6061T6S.188)
OR
ALUMINUM 5052-H32 SHEET PER QQ-A-250/8 OR AMS-QQ-A250/8
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4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER QSI 044 6.1
7) WEIGHT: 0.05 lbs

DESIGN	SC	**DART AEROSPACE LTD**
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. A
MFG. APPR.		D4314 SHEET 2 OF 2
APPROVED		TITLE SCALE
DE APPR.		SHIM NTS
DATE	11.01.13	

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